

Work Order ID 67411

Friday, March 18, 2011 2:22:50 PM

ASAP



Page 1

Item ID: D3955-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Template

Start Date: 3/21/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

WVF

Date: 11-03-18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3955

A

100

0.00



Waterjet

FLOW CNC Waterjet

6061 .040

Memo

1-Cut as per Dwg D3955

Dwg Rev: A

Prog Rev: 1

2-Deburr if necessary

0.00

B11-3-21

8

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B11-3-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

8 u103/21

0.00

Memo

(x5)

130



Packaging

Packaging

Identify as per dwg & Stock Location: 098

0.00

0.00

Memo

C4/3/21 @

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

u/3/21 J

C21103/21

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Picklist Print

Friday, March 18, 2011 2:22:47 PM

Page 1

Work Order ID: 67411



Parent Item: D3955-23



Parent Item Name: Template

Start Date: 3/21/2011

Required Date: 3/22/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.040

Purchased

No

sf

41.9300

1.668211

3.



B11-3-21

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT021

41.93

111224

0.4

113004

41.53

113004

8

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DART AEROSPACE LTD		Work Order: 6-7411
Description: Template		Part Number: D3955-23
Inspection Dwg: D3955	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.101	X		✓ 1B07	
Ø0.129	+0.005/-0.001	.130	X		✓	
0.750	+/-0.010	.751	✓		✓	
1.000	+/-0.010	1.000	X		✓	
1.250	+/-0.010	1.250	X		✓	
1.375	+/-0.010	1.373	✓		✓	
2.563	+/-0.010	2.563	✓		✓	
0.800	+/-0.010	.799	X		✓	
1.500	+/-0.010	1.501	✓		✓	
2.250	+/-0.010	2.254	✓		✓	
2.750	+/-0.010	2.751	✓		✓	
3.250	+/-0.010	3.250	✓		✓	
5.000	+/-0.010	5.000	✓		✓	
6.500	+/-0.010	6.500	✓		✓	
7.500	+/-0.010	7.501	✓		✓	
8.000	+/-0.010	7.998	✓		P	
8.500	+/-0.010	8.500	✓		P	
9.375	+/-0.010	9.377	✓		P	
9.625	+/-0.010	9.624	X		P	
10.600	+/-0.010	10.602	X		PROV502	
11.13	+/-0.030	11.128	✓		P	
0.040	+/-0.010	.039	✓		P	

Measured by: RB	Audited by: S	Prototype Approval: N/A
Date: 11-3-21	Date: 11/03/21	Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	

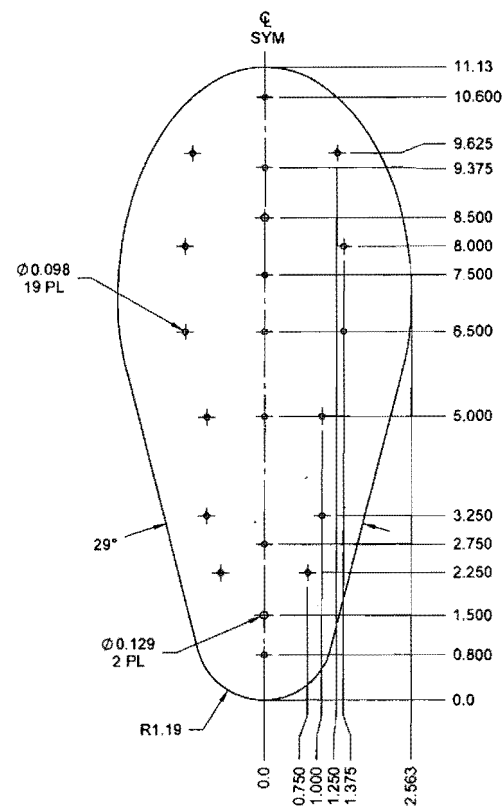
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D3955-23 TEMPLATE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.040 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.040)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-23" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.16 lbs

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV: A
MFG. APPR.		D3955	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
DATE	09.07.21	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS LOANED TO THE USER UNDER THE CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
09/07/21

467411

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